



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2932-2BL
Job Sheet 186102



Part No: D2932-2BL

Job Qty: 3 ea

Part Name: Saddle RH Out, 206



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/9/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Machining-1		SBL 18/11/21
100	CNC Vertical Machining	3 pcs	12/14/18	12/14/18	0.40	4.54	HAAS1-2		SBL 18/11/22
110	Mill Conv	3 pcs	12/14/18	12/14/18	0.00	4.53	Mill Conv 1		SBL 18/11/24
120	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC1		SBL 18/11/24
130	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC8 Machining-1		SBL 18/11/24
140	HandFinish	3 pcs	12/14/18	12/14/18	0.00	0.15	HandFinish1		DR 18/11/26
150	Outsource	3 pcs	12/14/18	12/14/18			ATE003-VC		DEC 18-11-28
155	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging2		DEC 18-11-28
160	QC	3 pcs	12/14/18	12/14/18	0.00	0.00	QC14		38
170	Packaging	3 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-1		DEC 18-11-28
180	QC21-SA	3 Ea	12/14/18	12/14/18	0.00	0.00	QC21		6

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - ***MASK ALL HOLES AS PAR16-484*** SPRAY PAINT BLEU P0041850

DAS
21
9-89

DEC 18 11 28

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-003	Saddle Billet, 7075	3 Ea (1 ea)	90-Start up Operation	30380542 S130144

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-003	3	63	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ Descript	DISPOSITION	AGAINST DEPARTMENT/PROCESS Part: D2932 – 2BL Job No: 186102 Serial No/Batch: S130146 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/21/18 Container No: S130146 Dart Aerospace Ltd. 1270 Aberdeen Street Newmarket, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com Water Jet _____ Prod. Eng. Coord. _____ Store/Packaging Supplier _____ Engineering Quality _____ Other _____ MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																																																																																																															
Root Cause <table border="1" style="width:100%; border-collapse: collapse;"> <tr><td>Environment</td><td>☐</td><td>No Re-verification</td><td>☐</td></tr> <tr><td>Design</td><td>☐</td><td>Operator</td><td>☐</td></tr> <tr><td>Doc/Data</td><td>☐</td><td>Offset/Setup</td><td>☐</td></tr> <tr><td>Equip/Tooling</td><td>☐</td><td>Supplier</td><td>☐</td></tr> <tr><td>Handling/Pre</td><td>☐</td><td>Training</td><td>☐</td></tr> <tr><td>Material</td><td>☐</td><td>Use for Testing</td><td>☐</td></tr> <tr><td>Internal Transport</td><td>☐</td><td>Poor Information</td><td>☐</td></tr> <tr><td>Tribal Knowledge</td><td>☐</td><td>Rushing</td><td>☐</td></tr> <tr><td>LOA</td><td>☐</td><td>Product Improvement</td><td>☐</td></tr> <tr><td>Substation</td><td>☐</td><td>Process Improvement</td><td>☐</td></tr> <tr><td>Past Expiry Date</td><td>☐</td><td>Manufacturing Process</td><td>☐</td></tr> <tr><td>Misidentified</td><td>☐</td><td>Past Due</td><td>☐</td></tr> </table> FAULT CATEGORY <table border="1" style="width:100%; border-collapse: collapse;"> <tr><td>Pressure/Forced</td><td>☐</td><td>Temperature/Cure</td><td>☐</td><td>Power Loss/Surge</td><td>☐</td><td>Positioned Wrong</td><td>☐</td></tr> <tr><td>Bending</td><td>☐</td><td>Set-up</td><td>☐</td><td>Folio/Program</td><td>☐</td><td>Outside Dimensions</td><td>☐</td></tr> <tr><td>Centre Not Concentric</td><td>☐</td><td>BOM/Route</td><td>☐</td><td>Grain</td><td>☐</td><td>Over/Under tolerance</td><td>☐</td></tr> <tr><td>Cracks</td><td>☐</td><td>Broken/Damage/Defect</td><td>☐</td><td>Weld</td><td>☐</td><td>Part Incorrect</td><td>☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave</td><td>☐</td><td>Inspection Incomplete/Unqualified</td><td>☐</td><td>Wrong Stock Pulled</td><td>☐</td><td>Part Lost/Missing</td><td>☐</td></tr> <tr><td>Cuffs</td><td>☐</td><td>Contamination</td><td>☐</td><td>Out of Sequence</td><td>☐</td><td>Part Moved</td><td>☐</td></tr> <tr><td>Crushing</td><td>☐</td><td>Countersink</td><td>☐</td><td>Off-set</td><td>☐</td><td>Drawing</td><td>☐</td></tr> <tr><td>Heat Treat</td><td>☐</td><td>Cut Too Short</td><td>☐</td><td>Mislabeled</td><td>☐</td><td>Finish</td><td>☐</td></tr> <tr><td>Wave/Twist in Tube</td><td>☐</td><td>Instructions Incomplete/Unclear</td><td>☐</td><td>Fit/Function</td><td>☐</td><td>Misread</td><td>☐</td></tr> <tr><td>Marks/Chatter</td><td>☐</td><td>Drill Holes</td><td>☐</td><td>Misaligned/off center</td><td>☐</td><td>Turning Sequence</td><td>☐</td></tr> </table>	Environment	☐	No Re-verification	☐	Design	☐	Operator	☐	Doc/Data	☐	Offset/Setup	☐	Equip/Tooling	☐	Supplier	☐	Handling/Pre	☐	Training	☐	Material	☐	Use for Testing	☐	Internal Transport	☐	Poor Information	☐	Tribal Knowledge	☐	Rushing	☐	LOA	☐	Product Improvement	☐	Substation	☐	Process Improvement	☐	Past Expiry Date	☐	Manufacturing Process	☐	Misidentified	☐	Past Due	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐	OTHER : _____
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DART AEROSPACE LTD	Work Order: 186102
Description: 206 Saddle, Outboard, Right side	Part Number: D2932-2
Inspection Dwg: D2932 Rev. C	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.116	0.126	0.127			
B	0.100	0.140		.116	0.127	0.126			
C	0.100	0.140		.115	0.125	0.123			
D	0.210	0.230		.223	0.223	0.223 ^s			
E	1.245	1.255		1.250	1.250	1.250			
F	1.245	1.255		1.250	1.250	1.250			
G	2.495	2.505		2.500	2.500	2.500			
H	0.510	0.515		.510	0.512	0.511			
I	1.572	1.582		1.577	1.577	1.577			
J	2.495	2.505		2.500	2.500	2.500			
K	0.257	0.262		.257	0.257	0.257			
L	0.312	0.317		.312	0.312	0.312			
M	0.235	0.240		.239	0.238	0.238			
N	0.100	0.140		.120	0.120	0.121			
O	0.540	0.560		.549	0.550	0.551			
P	0.490	0.510		.500	0.495 ^s	0.499			
Q	3.715	3.725		3.720	3.720	3.720			
R	2.470	2.510		2.495	2.495	2.497			
S	0.240	0.270		.254	0.254	0.254			
T	0.100	0.180		.135	0.135	0.139			
U	1.625	1.635		1.630	1.630	1.631			
V	1.362	1.372		1.367	1.368	1.368			
W	0.316	0.321		.316	0.316	0.316			
X	1.125	1.145		1.135	1.135	1.135			
Y	1.565	1.585		1.575	1.575	1.575			
Z	0.178	0.198		.188	0.188	0.188			
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: DAS
Date: 57 18/11/21
9-89

Audited by: <i>[Signature]</i>
Date: 18/11/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041880**

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO041880
PO Date: 11/28/18
Due Date:
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	186184	D4308-042BL	Step, RH Crew : Various STC's As per Dwg D4308 Rev A Prime and Spray Paint Delfleet Blue	Firmed	-	6x DEC 03 2018	6 pcs	0 pcs	6 pcs	\$40.00/pcs	\$240.00
2	186170	D2646BL	Aft Cap : Various STC's	Firmed	-	6x DEC 03 2018	6 pcs	0 pcs	6 pcs	\$21.00/pcs	\$126.00
3	186109	D3413-1BL	O-Ring : Various STC's SPRAY PAINT BLUE BATCH: _____	Firmed	-	10x DEC 03 2018	10 pcs	0 pcs	10 pcs	\$15.00/pcs	\$150.00
4	186107	D2939-1BL	Saddle LH In, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO _____	Firmed	-	4x DEC 03 2018	4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
5	186101	D2932-1BL	Saddle LH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** BATCH: _____	Firmed	-	4x DEC 03 2018	4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
6	186103	D2933-1BL	Saddle LH In, 206 : Various STC's *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____ ISSUE PO _____	Firmed	-	4x DEC 03 2018	4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
7	186106	D2938-2BL	Saddle RH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO _____	Firmed	-	3x DEC 03 2018	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00



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K6A 1K7
Canada

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PURCHASE ORDER **PO041880**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	186105	D2938-1BL	Saddle LH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	-	4 X DEC 03 2018	4 pcs	0 pcs	4 pcs	\$25.00/pcs	\$100.00
9	186102	D2932-2BL	Saddle RH Out, 206 : Various STC's ***MASK ALL HOLES AS PER PAR16-484*** SPRAY PAINT BLEU	Firmed	-	3 X DEC 03 2018	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00
10	186108	D2939-2BL	Saddle RH In, 206 : Various STC's ** MASK ALL HOLES AS PER PAR16-484***	Firmed	-	3 X DEC 03 2018	3 pcs	0 pcs	3 pcs	\$25.00/pcs	\$75.00
Grand Total:										\$1,141.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/28/18 1:16 PM dart.tsimiklis.chrisoula

